

Date: Tuesday, 12/12/2006 10:31:54 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 29904
 Estimate Number : 11876
 P.O. Number : N/A
 This Issue : 12/12/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 26768
 Written By : JA
 Checked & Approved By : JA 06/12/12
 Comment : est rev. A 06.01.14 new issue EC

Drawing Name : RIGHT ARM WELDMENT
 Part Number : D33547
 Drawing Number : D3354 REV.A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 1/10/2007

Qty: 16 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010B1000X02000 1010-1025 Steel Bar



Comment: Qty.: 0.5597 f(s)/Unit Total: 8.9544 f(s)

1010-1025 BAR

AISI 1010-1025 Steel bar 2.00" x 1.00"

Batch: M19296 J.F. 06/12/18

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 6.100" long

J.F. 06/12/18

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA611 and Dwg D3353

2- Debur

J.F. 06/12/18

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/12/18

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 06/12/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Handwritten Date: 07/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/12/2006 10:31:55 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 29904

Part Number: D33547

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(17)

Comment: FINAL INSPECTION/W/O RELEASE

DO 7/01/03

Job Completion



CL 07/01/03

I.D.
in stock.

ws.

LB 07/01/03

(17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

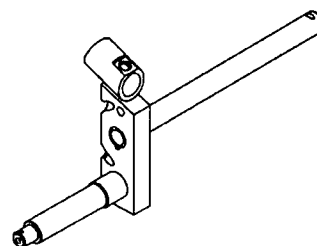
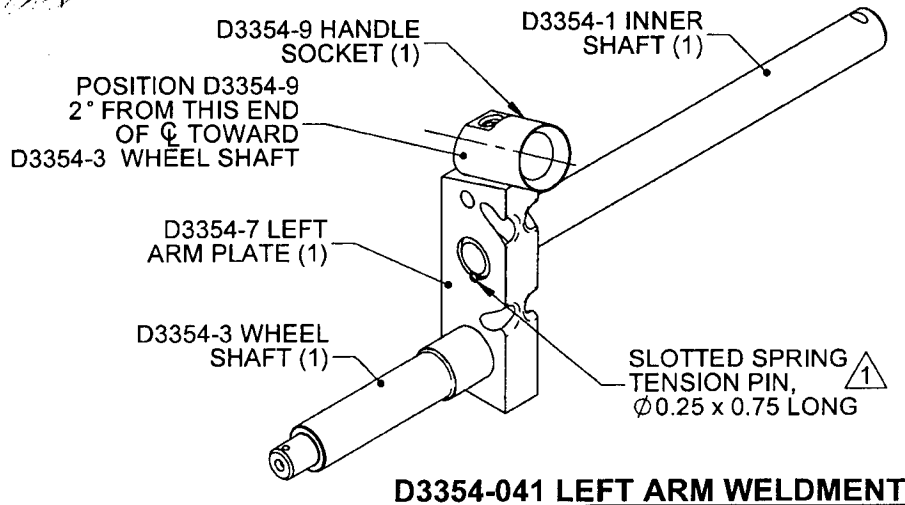
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

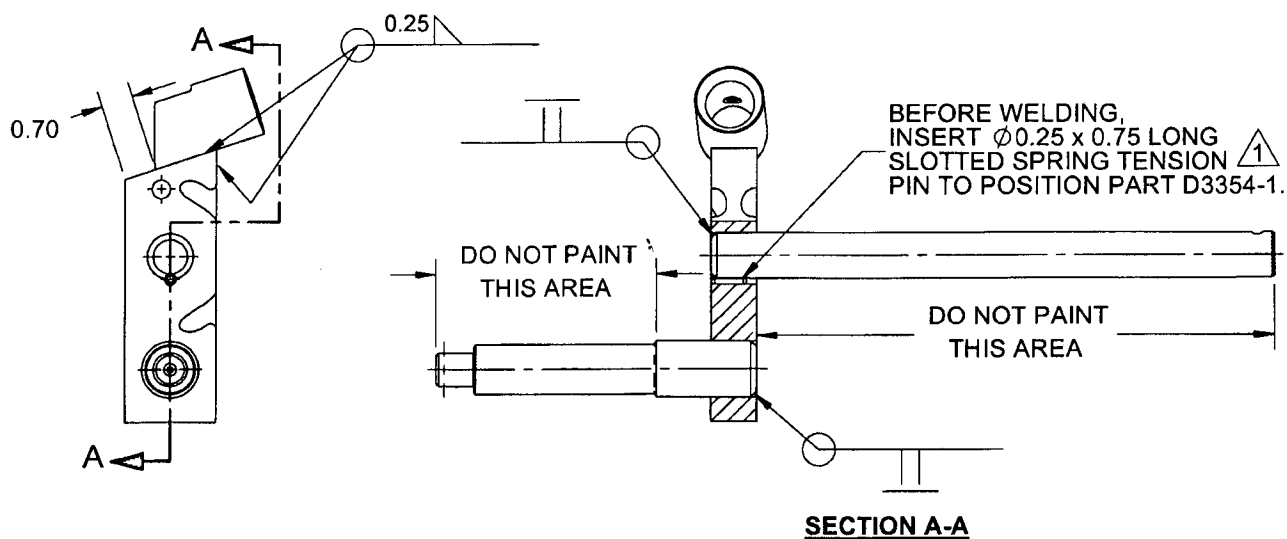


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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:4
A	04.12.13	NEW ISSUE	

RELEASED
86/02/02



**D3354-042 MIRROR
ARM WELDMENT**



NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005.4.8
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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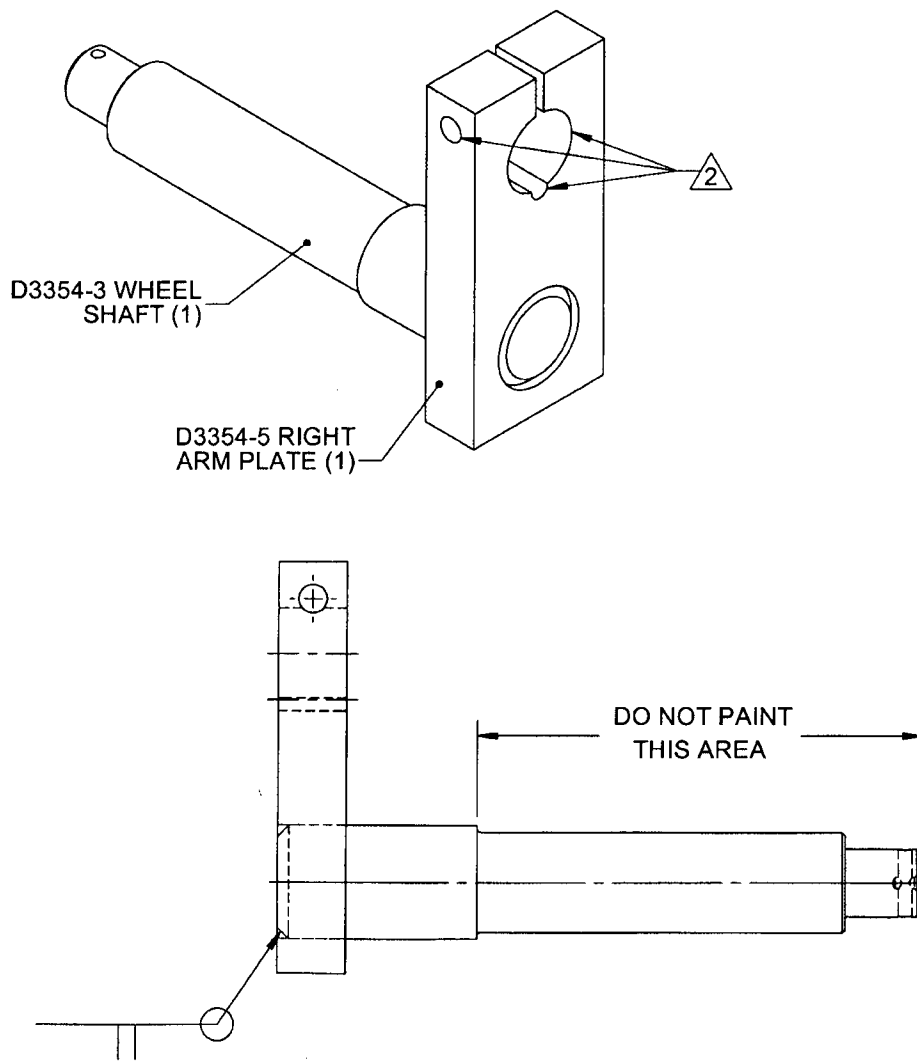
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
06/03/19

[Signature]

**D3354-043 RIGHT ARM WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

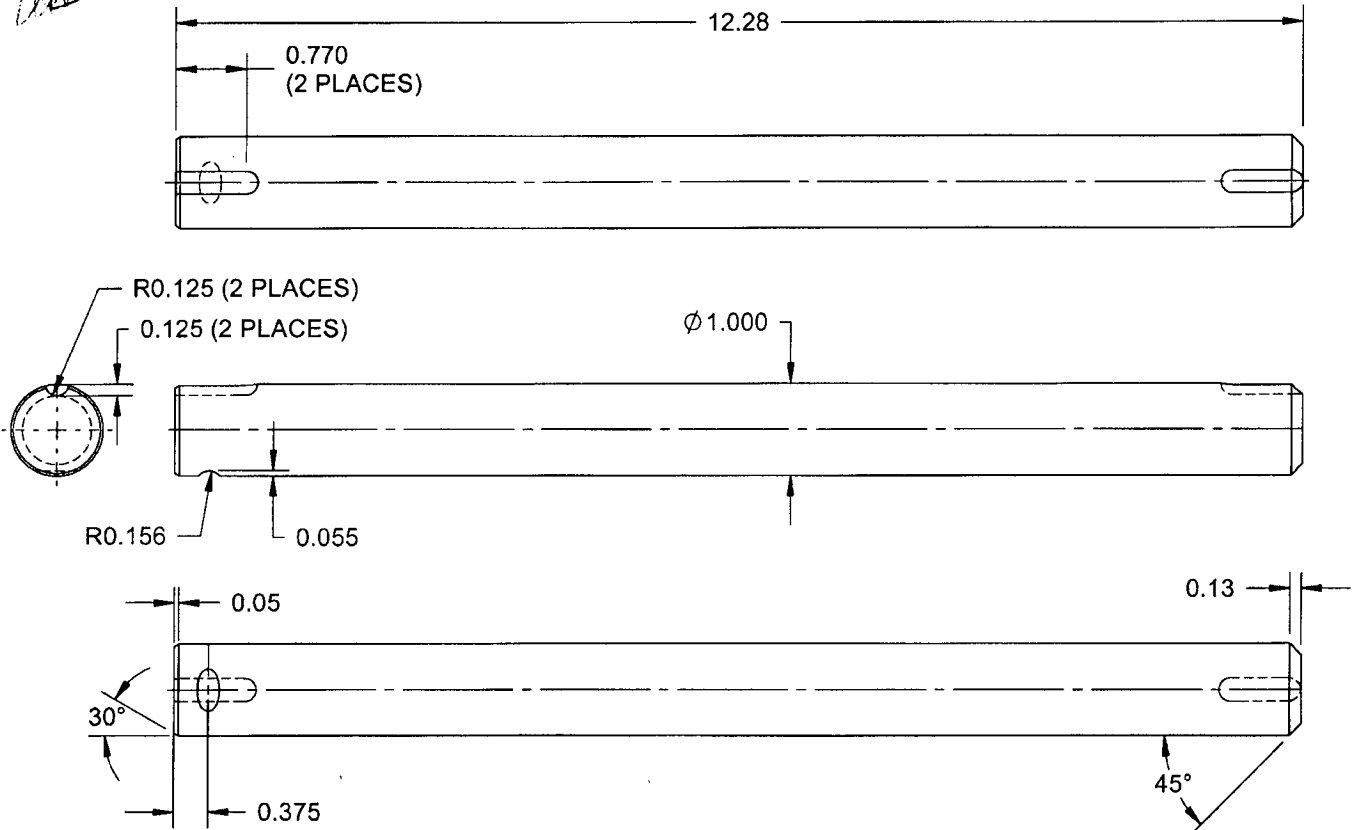
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
06/03/07**D3354-1 INNER SHAFT****NOTES:**

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A822-01D COPY OR UNS#-G41400 ROUND BAR, ϕ 1.250 (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

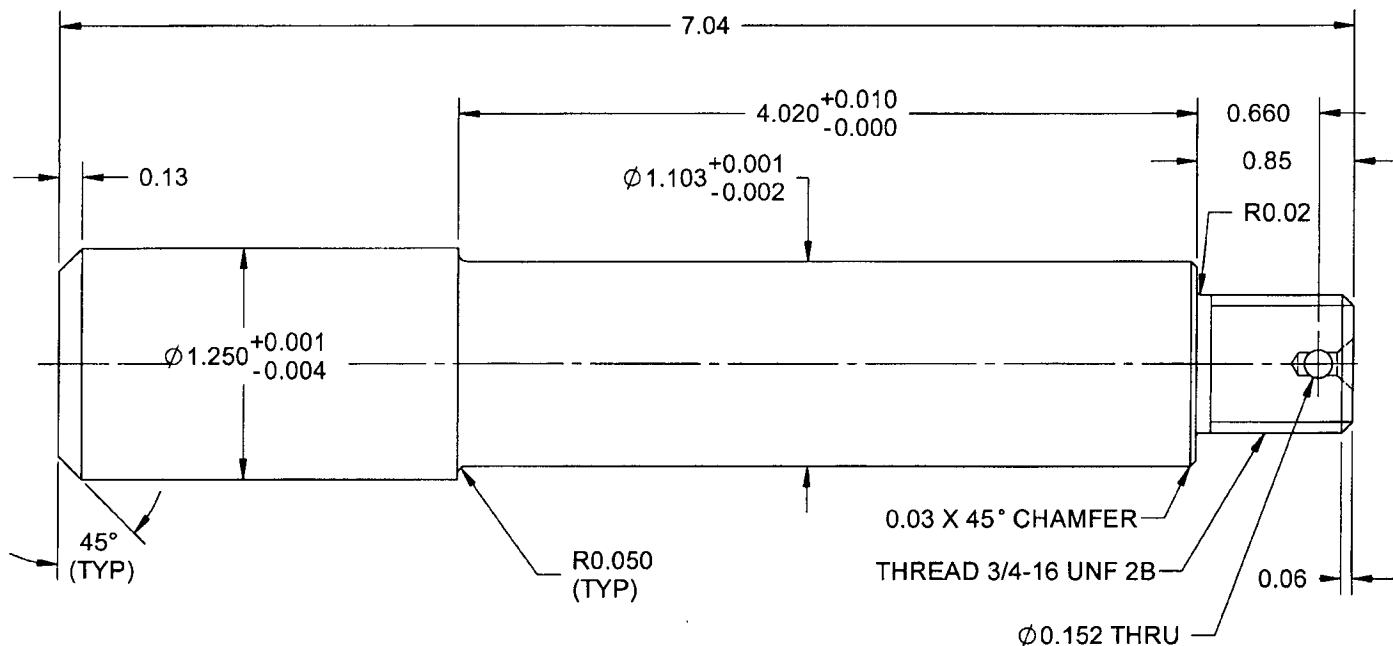
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:1

RELEASED
[Handwritten: 06/03/17]**D3354-3 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE B7/ A29-03/ A322-01 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

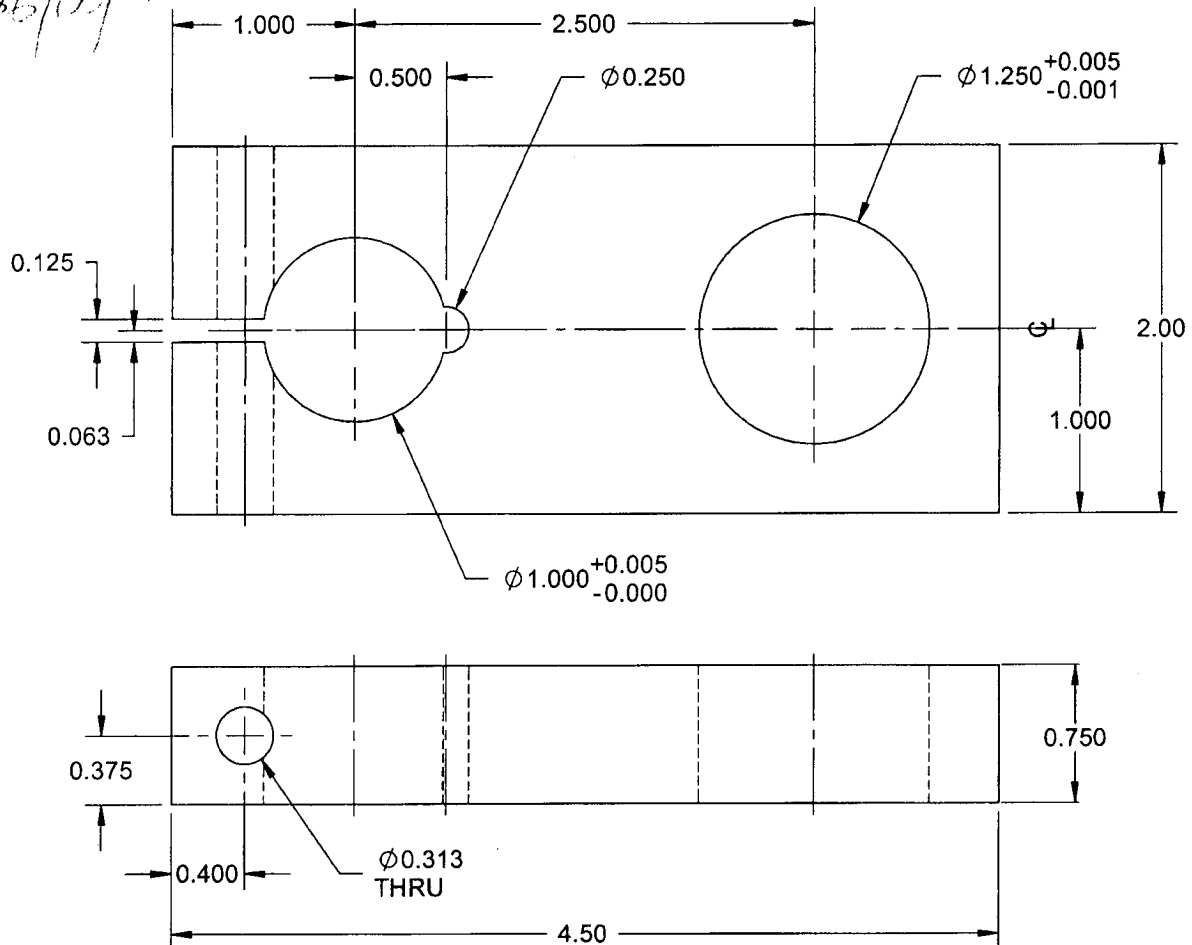
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:1

RELEASED
26/03/14**D3354-5 RIGHT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

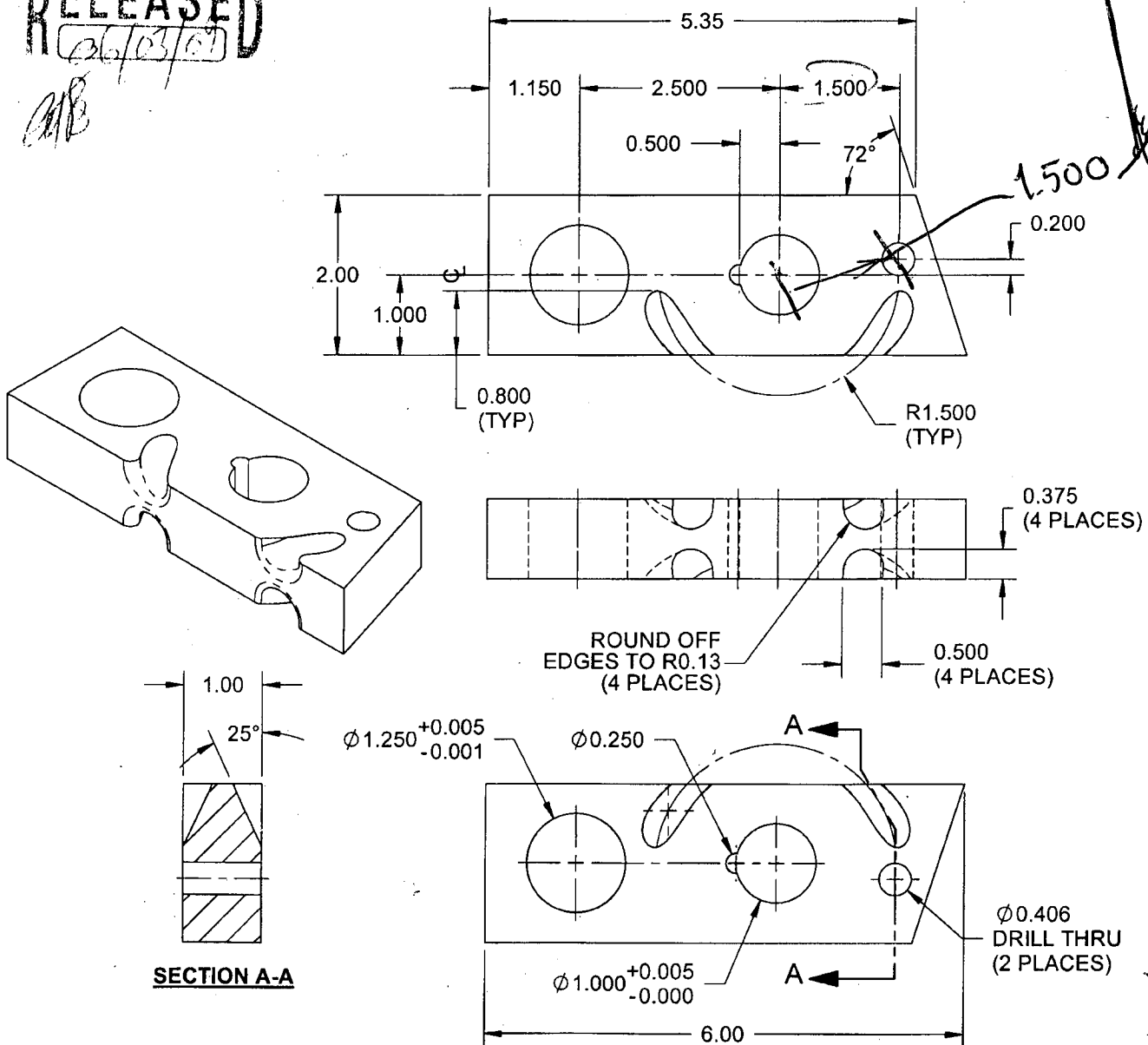
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
06/03/09**D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

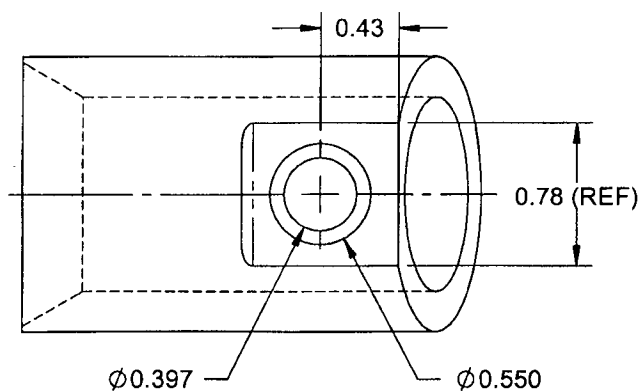
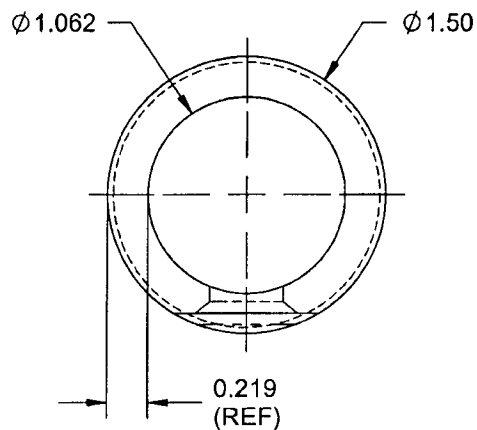
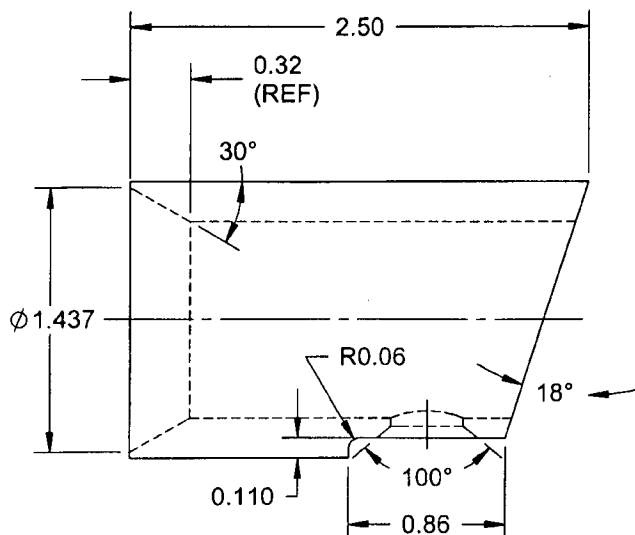
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:1

**D3354-9 HANDLE SOCKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DART AEROSPACE LTD		Work Order:
Description:		Part Number:
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

623 594
622 8255

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.35"	±.030"	5.340"	✓			
1.150"	±.010"	1.152"	✓			
2.500"	±.010"	2.502"	✓			
1.500"	±.010"	1.500"	✓			
.500"	±.010"	.501"	✓			
2.00"	±.030"	1.997"	✓			
1.000"	±.010"	.998"	✓			
.800"	±.010"	.810"	✓			
.200"	±.010"	.200"	✓			
1.00"	±.030"	1.001"	✓			
Ø 1.250"	±.005"	Ø 1.253"	✓			
Ø .250"	±.001"	Ø .251"	✓			
.375"	±.010"	.380"	✓			
.500"	±.010"	.500"	✓			
Ø 1.000"	±.005"	1.002"	✓			
Ø .406"	±.001"	Ø .407"	✓			
6.00"	±.030"	5.994"	✓			

Measured by: J.F.	Audited by: JL	Prototype Approval:
Date: 06/12/18	Date: 06/12/18	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

11/10/11

11/10/11

11/10/11

11/10/11

11/10/11

11/10/11

11/10/11